

Work Order ID 126953

126953

Page 2

Item ID: D3319-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Forward Wearplate

Stop

NS2

Start Date: 12/02/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/05/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
140	NC BRAKE								14/12/14
Brake NC	Memo	0.00				8	13		
Brake NC	1- Form using DT8326 & DT8261 as per Dwg D3319Rev: <u>C</u> 2- Form flat on press using DT8776 block								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									DAS 38 9-89
QC	Memo	0.00							
Quality Control									
160	Weld per dwg A/R Hardcoat steel Batch: _____	0.00							
160	Large Fab								14-12-14
Large Fab	Memo	0.00							
Large Fab	1- Layout weld location as per Dwg D3319 using jig D3319-1T3 2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: _____								
	Qty Part Number Description Batch								
	A/R N/A 228/7560 Hardcoat Rod								130/166

DEC 04 2014

13

14-12-14

100

Work Order ID 126953***126953***

Page 3

December-02-14 2:17:49 PM

Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Forward Wearplate
Start Date: 12/02/14 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 12/05/14 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		Cpl		13	14-12-22		DAS 50 9-89
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(13)	14-12-22		DAS 9 9-89
190 *190* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 m 128564. Memo START TIME: 8:15 OVEN TEMPERATURE: 320 FINISH TIME: 8:45	0.00 0.00				13	14-12-23		DAS 34 9-89

Picklist Print

December-02-14 2:17:48 PM

Page 1

Work Order ID: 126953

126953

Parent Item: D3319-1

D3319-1

Parent Item Name: Forward Wearplate

Start Date: 12/02/14

Required Date: 12/05/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B05.10.14Added step 9, dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S18GA

Purchased

No

100

sf

112.7608

0.628

8

DAS
23
9-89

M1010S18GA

1010/1025 SHEET .048

**

14-12-3

Location

Loc Qty

Loc Code

MAT019

112.7608

116268

0.970948

117806

18

124428

20.4899

m129674

33.3

m130454

40

129674

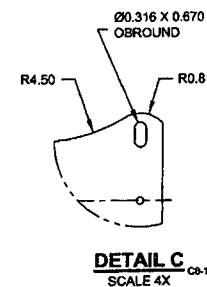
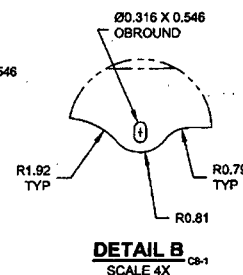
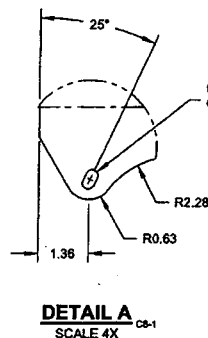
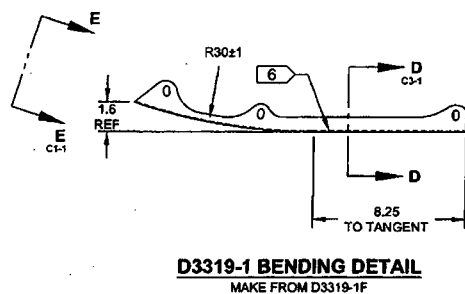
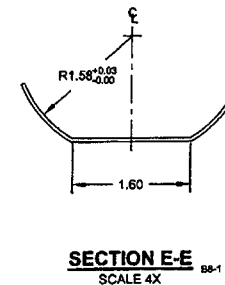
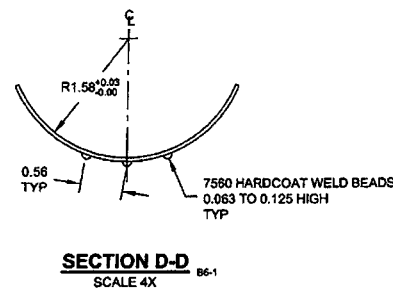
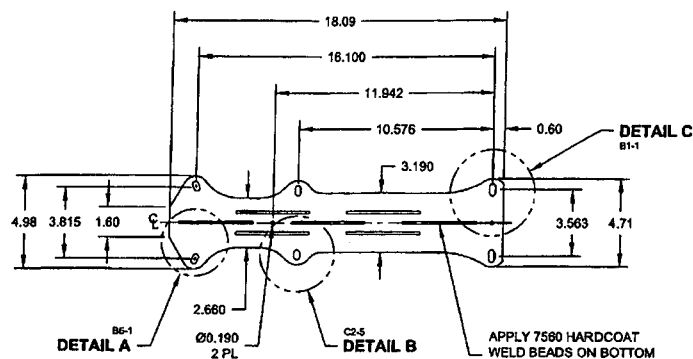
DART AEROSPACE LTD		Work Order: 126953
Description: Wearplate		Part Number: D3319-1
Inspection Dwg: D3319	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.98	+/-0.030	4.98	-		V	Jkm01
1.600	+/-0.010	1.600	-		V	
2.660	+/-0.010	2.660	-		V	
3.190	+/-0.010	3.190	-		V	
3.563	+/-0.010	3.563	-		V	
4.71	+/-0.030	4.71	-		V	
0.60	+/-0.030	0.605	-		V	
10.576	+/-0.010	10.576	-		V	Jkm08
11.942	+/-0.010	11.942	-		V	
18.09	+/-0.030	18.09	-		T	
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	0.316 x 0.548	-		V	
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	0.318 x 0.678	-		V	
Ø0.190	+0.005/-0.001	0.191	-		V	
3.815	+/-0.010	3.815	-		V	
16.100	+/-0.010	16.100	-		T	Jkm07

Measured by: DAS 23 9-89	Audited by: DAS 38 9-89	Preliminary Approval:
Date: 14-12-3	Date: DEC 03 2014	Date:

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	



D3319-1 WEARPLATE

NOTES:

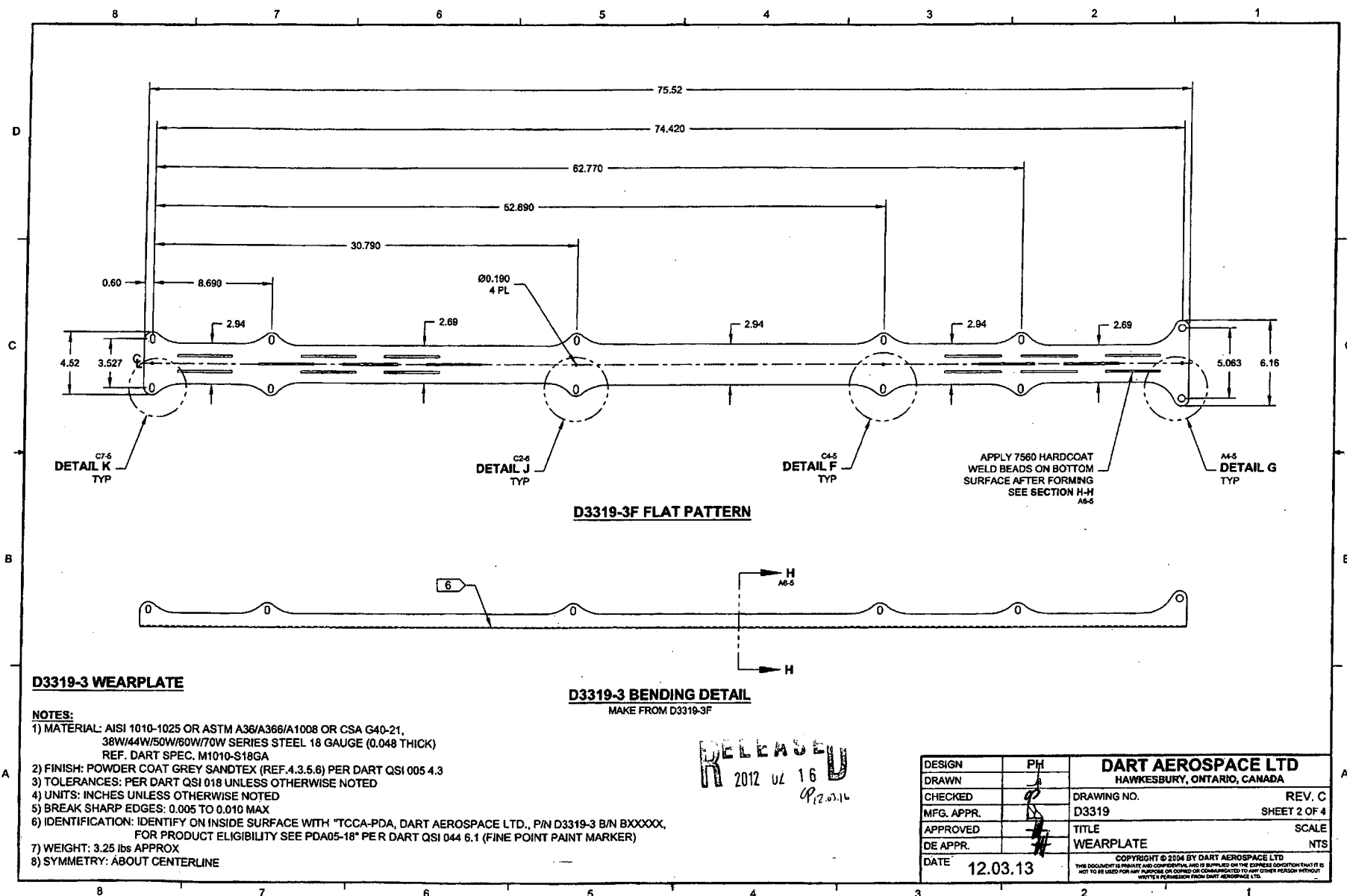
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- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

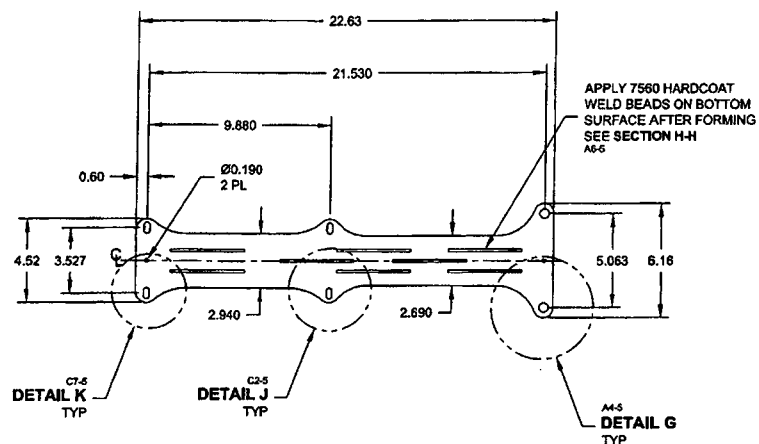
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2012-03-16
PER ECN 12-546 R12-03.16

14-12-03
126953

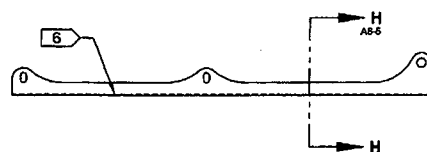
C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT MOST HOLE ON -3/5-7 (REF DETAIL G); SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/5-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D3319 TITLE WEARPLATE SCALE NTS	
DATE	12.03.13	REV. C SHEET 1 OF 4	

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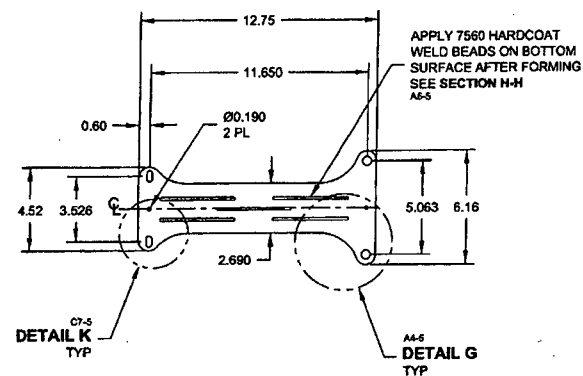




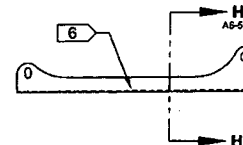
D3319-5F FLAT PATTERN



D3319-5 BENDING DETAIL
MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL
MAKE FROM D3319-7F

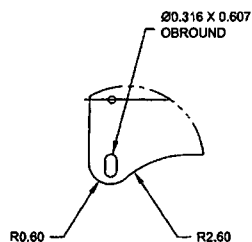
D3319-5/-7 WEARPLATE

NOTES:

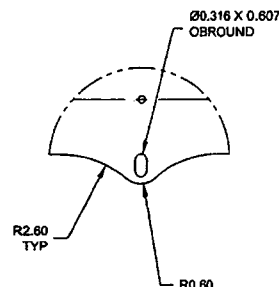
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-02-16
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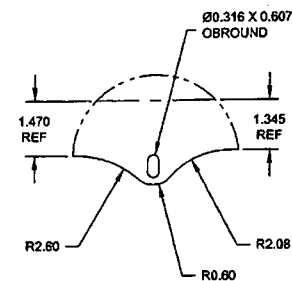
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NT
DATE	12.03.13	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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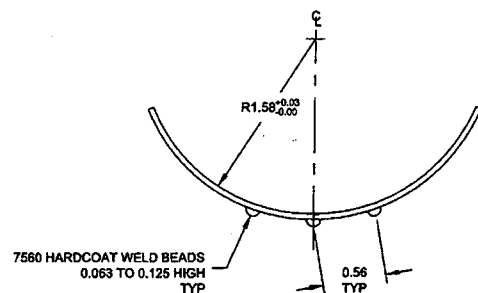
DETAIL K
SCALE 2X
B8-2
C4-3
C6-3



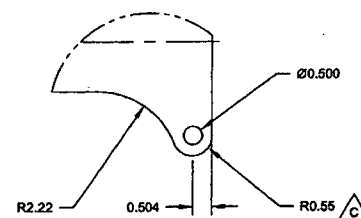
DETAIL F
SCALE 2X
B8-2



DETAIL J
SCALE 2X
B8-2
C7-3



SECTION H-H
SCALE 4X
B4-2
B3-3
B6-3



DETAIL G
SCALE 2X
B8-2
C2-3
C6-3
C

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2012-02-16
P. 12.03.16

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DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	D	DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
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